

Slip 14/09

Dart Aerospace Ltd.

Date: Thursday, 06/09/2007 12:48:34 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 34446		
Estimate Number	: 12403		
P.O. Number	: <i>N/A</i>	Part Number	: D3511041
This Issue	: 06/09/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3511 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 34220	Drawing Revision	: A
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 14/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	2 Um: Each
Comment	: Est Rev:A New Issue 06-05-04 JLM : Est Rev:B New process-06-05-05 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D35031	CUP
Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) CUP Batch: <i>B28277</i> <i>FC 07 09 06 (2)</i>		
2.0	D35111	WEARPLATE
Comment: Qty.: 1.0000 (s)/Unit Total : 2.0000 (s) WEARPLATE <i>B 27006 FC 07 09 06 (2)</i>		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 <i>N/A</i> <i>don't 27006 from sth</i> Bend fwd 90 deg. bend per dwg D3511		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>already bent</i>		
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld as per Dwg D3511 A/R SS ROD Batch: <i>m104721</i> <i>FC 07/09/07 (2)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Form as per Dwg D3511

18 0709-11 (2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1207/09/07 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 0709/13 (42)

9.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 07/09/15 (2x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07 09 16



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

5275 07/17/17 (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



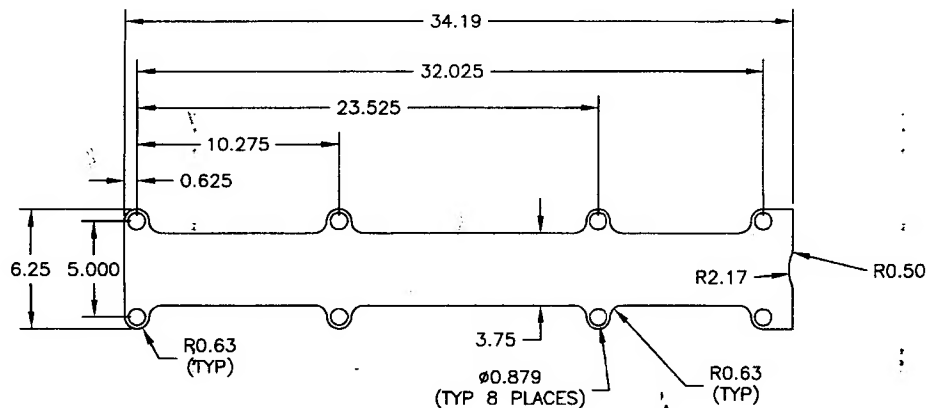
Comment: FINAL INSPECTION/W/O RELEASE

07/17/17 (2)

Job Completion

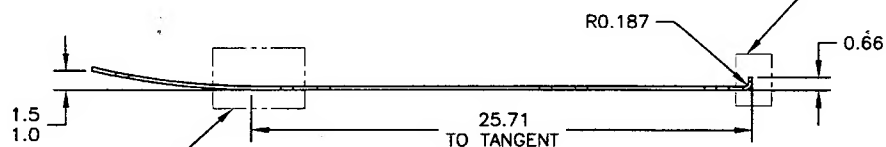


07/09/17



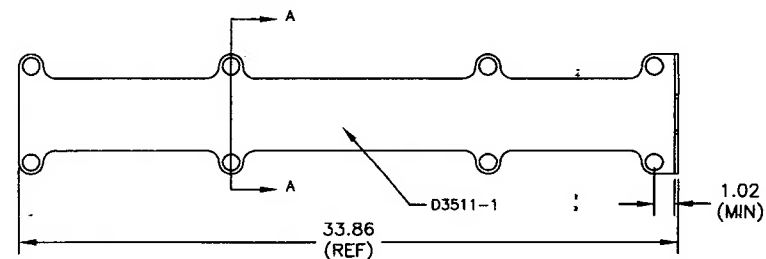
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

w/o 34446

RELEASED

06 04 25

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
3	D3503-1	CUP

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		CHECKED	APPROVED	DRAWING NO.
		DATE		D3511
				TITLE
				WEARPLATE
				SCALE
				NTS

REV. A

SHEET 1 OF 1